



## CAL Document Change Notification

DCN No.  
7650-DCN-0039-01

CHANGE TITLE: Bond Line Thickness Change For CDE

Internal External

ORIGINATOR: Paul Dizon

DATE: 16-Apr-04

NEXT ASSY: LAT-DS-00916

DOC or DWG NUMBER	TITLE	AFFECTED REV.	NEW REV.
LAT-DS-01900	Crystal Detector Element, Calorimeter, Glast	05	06

### CHANGE DESCRIPTION:

- 1) Change bond line thickness (Zone B-2, page 2) to "0.8 TO 1.1 MAX BOND THICKNESS".
- 2) Add "APPROX" to the following seam tape dimension (Zone B-1, page 1):  
12.7, APPROX
- 3) Add "APPROX" to the following seam tape and optical wrap dimensions (Zones A-1, D-1, D-2, page 2):  
4 TO 7, APPROX  
311 TO 316, APPROX  
0.7, APPROX, ALLOWABLE MISMATCH LAT-DS-02159

### REASON FOR CHANGE:

Need to increase bond thickness due to process. Optical properties and interference with structure is not affected.

Seam tape dimensions changed to approximate dimensions and notes edited to simplify inspection.

### DISPOSITION OF HARDWARE:

No hardware affected

Serial numbers affected: ALL

Effective date: 16-Apr-04

	Use as is	Retest	Rework	Scrap	Other/Comment
Raw material					
Parts in process					No Affect
Assemblies					

APPROVALS		DATE	OTHER APPROVALS (specify):	DATE
ORIGINATOR:	<i>P. Dizon</i>	4/19/04	:	
SUBSYSTEM MANAGER:	<i>P. Dizon</i>	4/19/04	:	
PROJECT MANAGER:	<i>W.C. Raynor</i>	4/19/04	:	
QUAL ASSUR. MANAGER:	<i>J. Lee</i>	4/19/04	:	
CONFIGURED AND RELEASED:	<i>P. Sandora</i>	4/19/04		





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### Continuation:

- 4) Add "APPROX" to end cap tape dimensions (Zone B-1, A-3 and B-3, page 1)

3 - 4, APPROX  
16 +2/0, APPROX  
22 +3/0, APPROX  
9.525, APPROX

- 5) Edited the following NOTES (page 1) to:

"6. DIMENSIONS TO PDA FROM SURFACE OF CRYSTAL CONTROLLED BY MANUFACTURING PROCESS"

"7. SEAM TAPE SHALL END BENEATH THE END CAP TAPE, BUT SHALL NOT END BENEATH FLANGE OF END CAP"

- 6) Added the following NOTES (page 1):

"8. FOR THE PURPOSE OF MANUFACTURING PROCESS CONTROL VERIFICATION, INSPECT BONDLIN TO LESS THAN OR EQUAL TO 1.0 mm THICKNESS X 5.0 mm WIDTH"

"9. DIMENSIONS INDICATED ARE FOR REFERENCE PURPOSES ONLY AND NOT FOR INSPECTION"

- 7) Edit the following note flags:

Zone A-3, page 1: Edit note to "SEE NOTES 5 AND 9" for 16 +2/0 APPROX dimension

Zone B-3, page 1: Edit note to "SEE NOTES 5 AND 9" for 22 +3/0 APPROX dimension

Zone A-1, page 2: Edit note to "SEE NOTES 7 AND 9" for (4 TO 7) APPROX dimension

- 8) Added note flags:

Zone C-2, page 1: Add "FLANGE, SEE NOTE 7" to end cap flange of isometric view

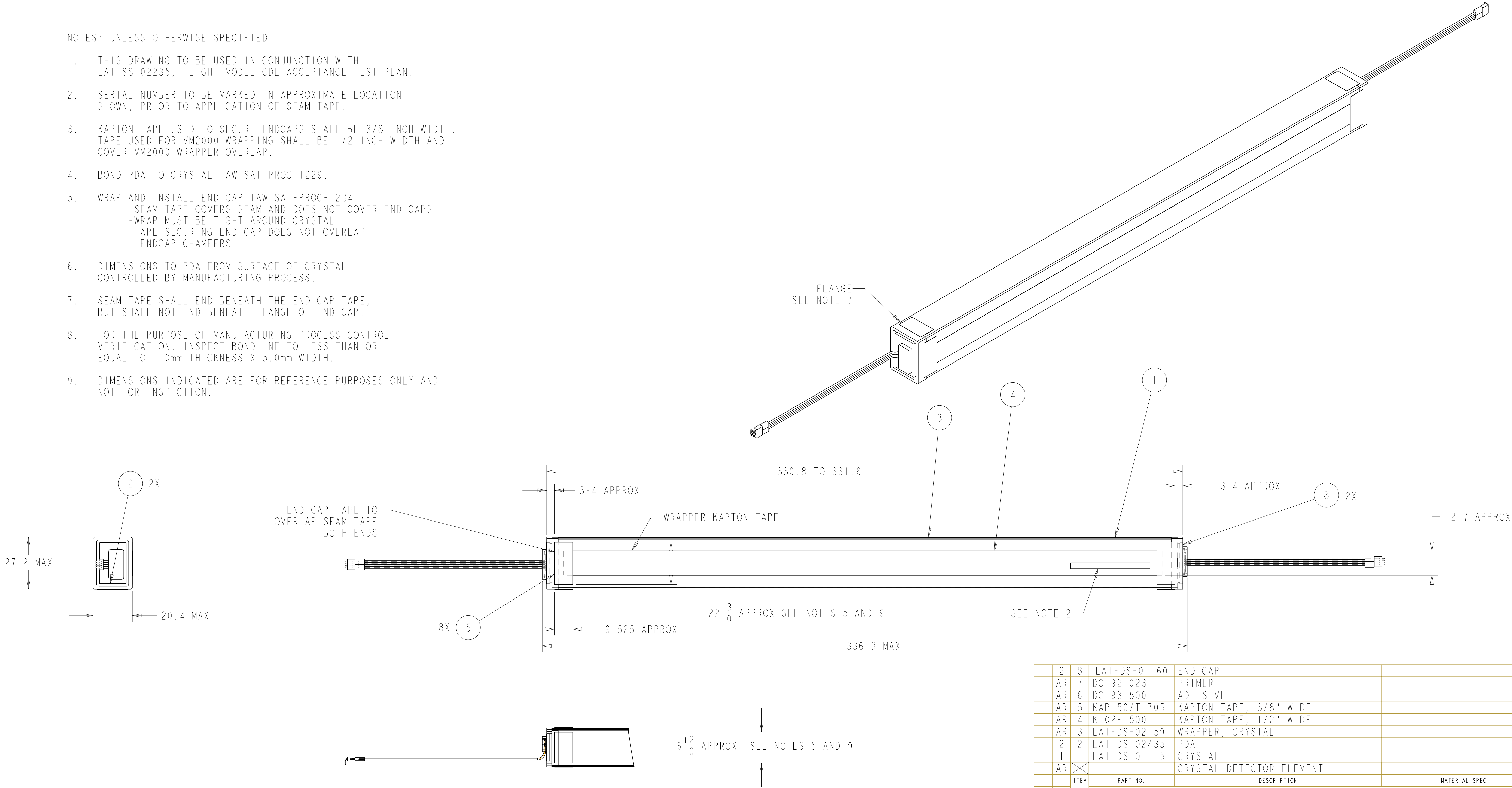
Zone B-1, page 2: Add "SEE NOTE 8" to 0.8 TO 1.1 MAX BOND THICKNESS dimension



REVISION				
SYM	ZONE	DESCRIPTION	DATE	APPROVAL

NOTES: UNLESS OTHERWISE SPECIFIED

- THIS DRAWING TO BE USED IN CONJUNCTION WITH LAT-SS-02235, FLIGHT MODEL CDE ACCEPTANCE TEST PLAN.
- SERIAL NUMBER TO BE MARKED IN APPROXIMATE LOCATION SHOWN, PRIOR TO APPLICATION OF SEAM TAPE.
- KAPTON TAPE USED TO SECURE ENDCAPS SHALL BE 3/8 INCH WIDTH. TAPE USED FOR VM2000 WRAPPING SHALL BE 1/2 INCH WIDTH AND COVER VM2000 WRAPPER OVERLAP.
- BOND PDA TO CRYSTAL IAW SAI-PROC-1229.
- WRAP AND INSTALL END CAP IAW SAI-PROC-1234.
  - SEAM TAPE COVERS SEAM AND DOES NOT COVER END CAPS
  - WRAP MUST BE TIGHT AROUND CRYSTAL
  - TAPE SECURING END CAP DOES NOT OVERLAP ENDCAP CHAMFERS
- DIMENSIONS TO PDA FROM SURFACE OF CRYSTAL CONTROLLED BY MANUFACTURING PROCESS.
- SEAM TAPE SHALL END BENEATH THE END CAP TAPE, BUT SHALL NOT END BENEATH FLANGE OF END CAP.
- FOR THE PURPOSE OF MANUFACTURING PROCESS CONTROL VERIFICATION, INSPECT BONDLINE TO LESS THAN OR EQUAL TO 1.0mm THICKNESS X 5.0mm WIDTH.
- DIMENSIONS INDICATED ARE FOR REFERENCE PURPOSES ONLY AND NOT FOR INSPECTION.



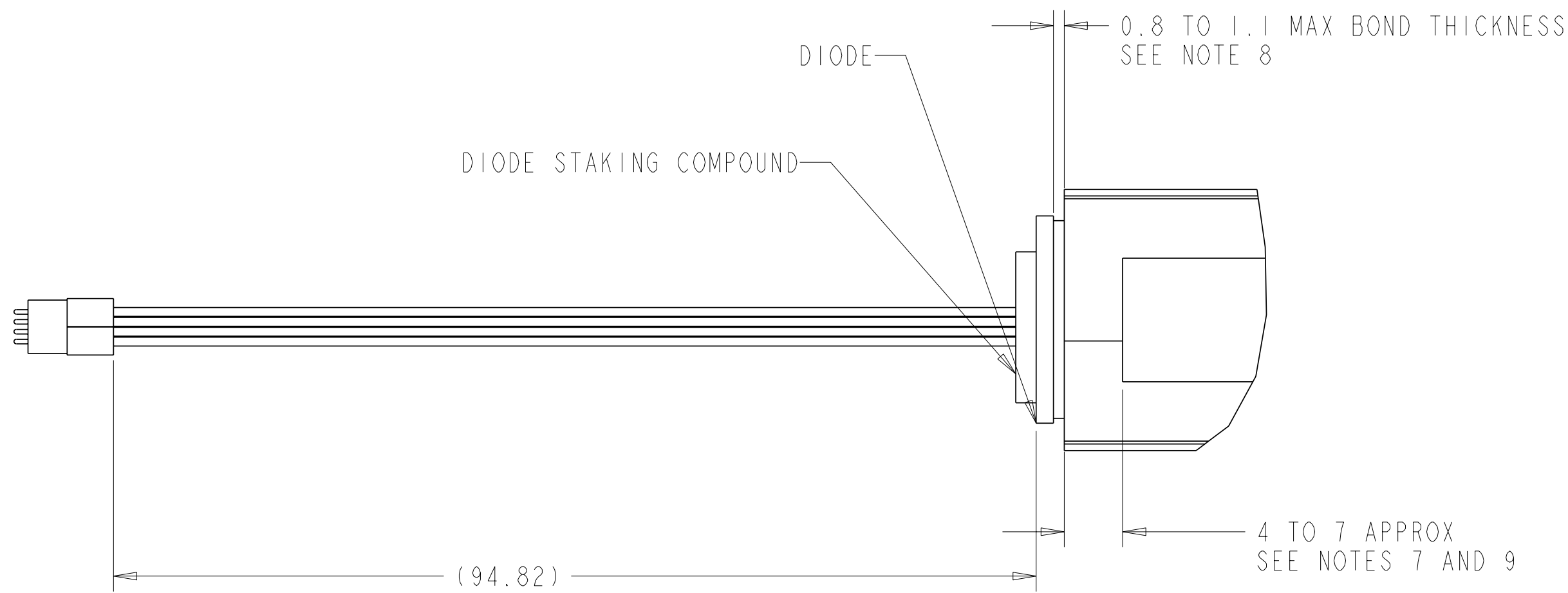
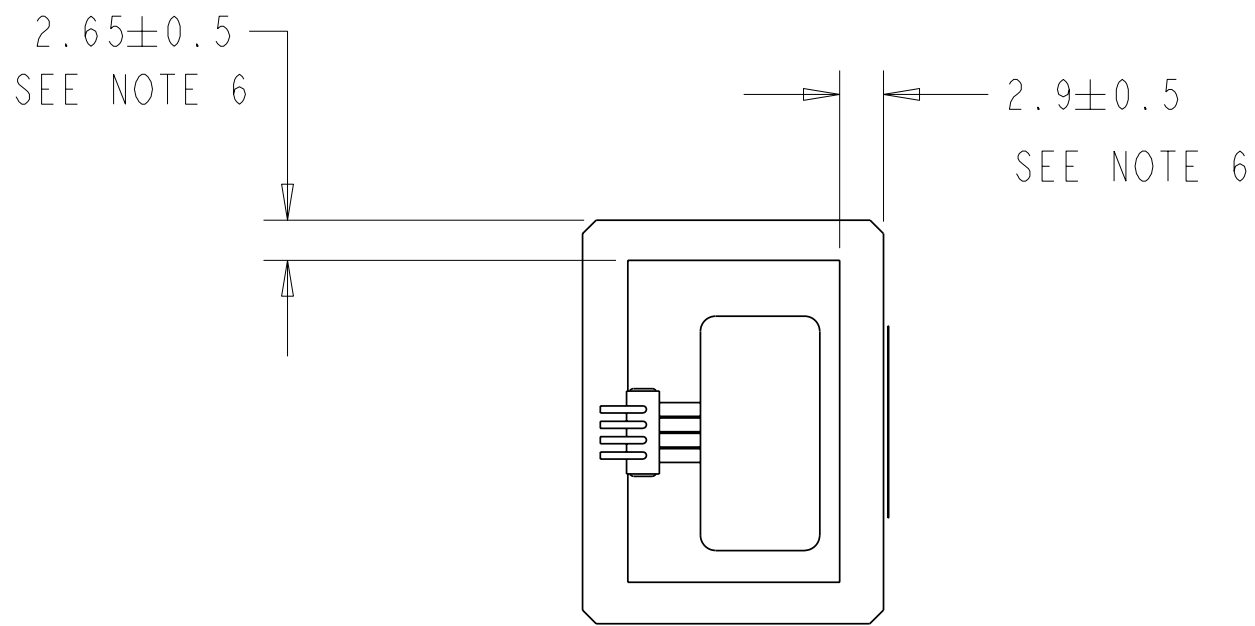
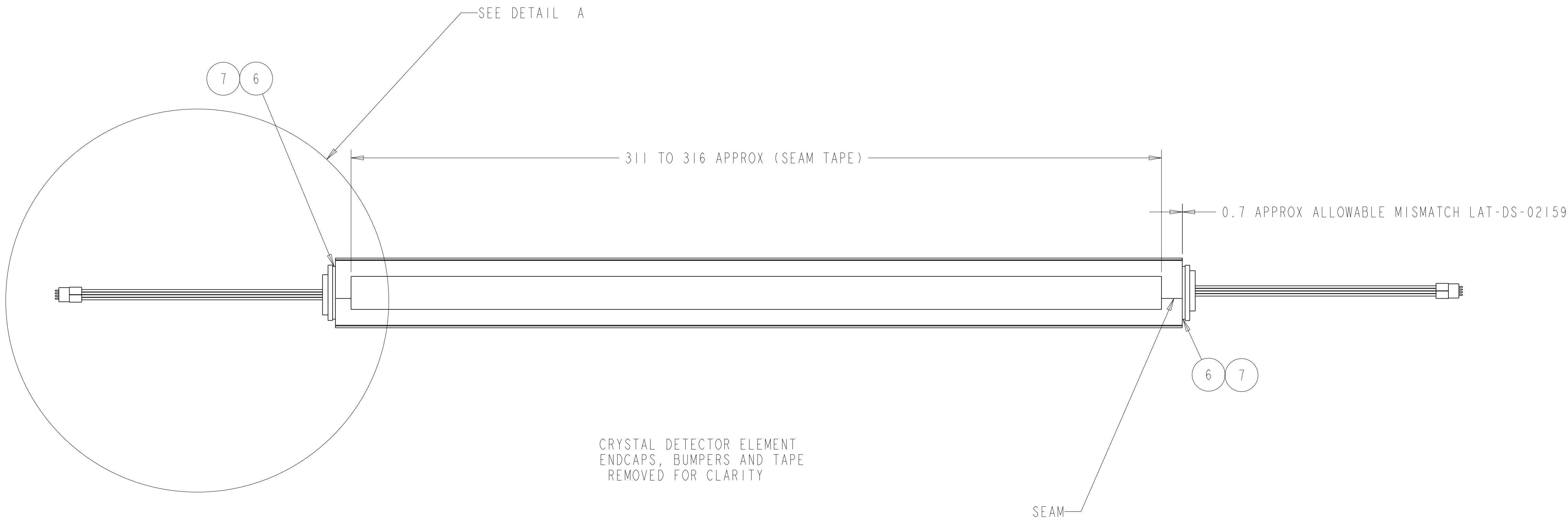
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GLAST-CAL CM  
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RELEASED  
FOR  
MANUFACTURE

20 APRIL 2004

2	8	LAT-DS-01160	END CAP		
AR	7	DC 92-023	PRIMER		
AR	6	DC 93-500	ADHESIVE		
AR	5	KAP-50/T-705	KAPTON TAPE, 3/8" WIDE		
AR	4	K102-.500	KAPTON TAPE, 1/2" WIDE		
AR	3	LAT-DS-02159	WRAPPER, CRYSTAL		
2	2	LAT-DS-02435	PDA		
1	1	LAT-DS-01115	CRYSTAL		
AR	X		CRYSTAL DETECTOR ELEMENT		
RECD	RECD	ITEM NO	PART NO.	DESCRIPTION	MATERIAL SPEC
LIST OF MATERIAL					
			NAME	INIT	DATE
			DESIGNER		
			DRAWN BY K. Woiko	KW	4/20/04
			CHECKED P. Dizon	PVD	4/20/04
			APPROVED-STRESS		
			APPROVED-QA J. Lee	JWL	4/20/04
			APPROVED-ENGINEER P. Dizon	PVD	4/20/04
			APPROVED B. Raynor	WCR	4/20/04
			APPROVED		
			GLAST		
			NEXT ASSY	USED ON	
			TASK NO: xxx		
UNLESS OTHERWISE SPECIFIED: ALL DIMENSION ARE IN MILLIMETERS AND APPLY AFTER FINISH DIMENSION TOLERANCES			GLAST		
0. X ±0.1 X ±0.15 XX ±0.3 XXX ±0.6 XXXX ±1.5			ANGLE ±0.5°		
FINISH IN MICROMETERS			INTERPRET DRAWING PER ANSI Y14.5M-1982 REMOVE ALL BURRS AND SHARP EDGES R0.25 OR CHAMFER MAX		
MODEL NAME: NEW GLAST CRYSTAL DIODE ASSEMBLY DRW VERSION: PRO/ENGINEER VERSION: 2001			D		
CAGE CODE 8V543			LAT-DS-01900		
SCALE: 1:000			REV 06		
WT APPROX: -			1 OF 2		

REVISION				
SYM	ZONE	DESCRIPTION	DATE	APPROVAL



DETAIL A  
SCALE 2.000

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RELEASED  
FOR  
MANUFACTURE  
20 APRIL 2004

NAME	INIT	DATE	CAGE CODE	LAT-DS-01900		REV
CHECKED P. Dizon	PVD	4/20/04	8V543	SCALE 1:000	WT "	SH 2 OF 2
APPROVED-ENGR P. Dizon	PVD	4/20/04	FILE NAME: LAT-DS-01900	MODEL NAME: NEW-GLAST-CRYSTAL-DIODE-ASSY		